

Work Order ID 104684

\*104684\*

Page 1

July-12-13 2:41:07 PM

Item ID: D4770-5

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bar

Start Date: 7/12/13

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/19/13

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4770

A

100

0.00

\*100\*

Cold Saw

Hyd Mech

Memo

Cut blanks as per dwg

0.00

13-07-15

2

110

0.00

\*110\*

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB182 & dwg D4770-5,

FOLIO REV:

DWG REV:

NA Manual  
A

0.00

13-07-15

2

2-Deburr as required

\*\*\*EXTRA MATERIAL WILL BE CUT AT ASSEMBLY\*\*\*

Work Order ID 104684

\*104684\*

Page 2

July-12-13 2:41:07 PM

Item ID: D4770-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bar  
 Start Date: 7/12/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		13-07-15		2			
130 *130* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		13-7-15		2			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: 14001  Memo	0.00 0.00				2	772	13-07-16	

Work Order ID 104684

\*104684\*

Page 3

July-12-13 2:41:07 PM

Item ID: D4770-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Bar

Stop \*NS2\*

Start Date: 7/12/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 7/19/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

13/7/17

ME  
13-7-16

# Picklist Print

July-12-13 2:41:06 PM

Page 1

Work Order ID: 104684  
Parent Item: D4770-5  
Parent Item Name: Bar

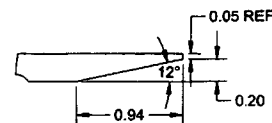
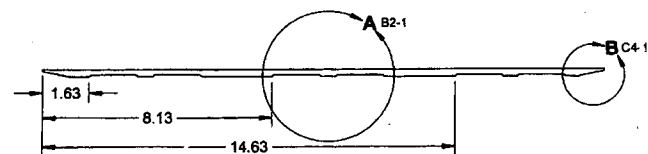
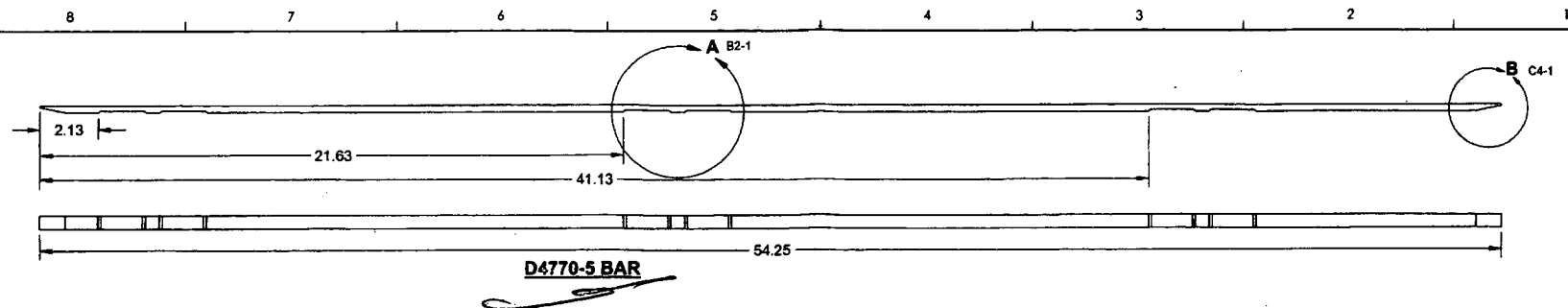
Start Date: 7/12/13  
Start Qty: 2.00  
Required Date: 7/19/13  
Required Qty: 2.00

Comments: IPP REV:A 13.04.01 NEW ISSUE DD VERF:JLM

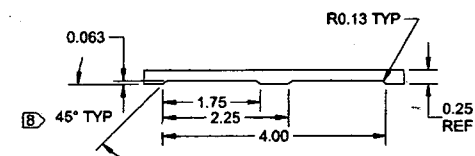
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	331.2483	4.52	9.5157895			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT049	331.2483	
124518	28.365	
m126151	302.8833	

9.6 ~~13~~ 13-07-15



**DETAIL B** D1-1, C5-1, B1-2  
SCALE 4X  
TYPICAL BOTH ENDS



**DETAIL A** D5-1, C7-1, B5-2  
1 3 PL  
3 6 PL  
5 3 PL  
SCALE 2X

RELEASED  
2013-03-25

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240  
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4770-1=60 lbs, D4770-5=1.84 lbs
- 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING

A NEW RELEASE		DB	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	AP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.02.13		

**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO. **D4770** REV. A  
SHEET 1 OF 2  
TITLE **BAR** SCALE NTS

COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

